



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-C-03

Job Sheet 170611



Part No: RBE350A94-3700-C-03

Job Qty: 18 ea

Part Name: Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		2/13/18	0.00	0.00	Start Up Machining-4		SC-L
120	Lathe Conv	18 pcs		2/13/18	5.00	0.00	Lathe Conv-2		SC-L
130	QC	18 pcs		2/13/18	0.00	0.00	QC2 Machining-3		SC-L 18-02-14
140	Mill Conv	18 pcs		2/13/18	0.00	3.60	Mill Conv 2		SC-L
150	QC	18 pcs		2/13/18	0.00	0.00	QC2 Machining-5		SC-L 18-02-15
160	QC	18 pcs		2/13/18	0.00	0.00	QC8 Machining-5		SA 18-02-16
170	Outsource	18 pcs		2/13/18	0.00	0.00	Outsource12		AP 18/03/18
180	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging2		AP 18/03/18
190	QC	18 pcs		2/13/18	0.00	0.00	QC6		DAG 38
200	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging3-2		6 9-88
210	QC21-SA	18 Ea		2/13/18	0.00	0.00	QC21		MAR 13 2018

Part Op 120 - 1-Machine as per DWG 2-Debur

Descriptions: 140 - 1-Machine as per DWG 2-Debur

170 - Issue P/O to Groupe Altech; PO 039090 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92580A112	Threaded Rod 5/8-18	5.4000 ft (.3 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:36 AM Dart.lajeunesse.marie

DART
AEROSPACE
S041503

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



Bolt

PART NO: RBE350A94 - 3700 - C - 03

Original Serial #: S041503

Revision:

Operation: Start up Operation 02/12/18

Change No:

Job No: 170611

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

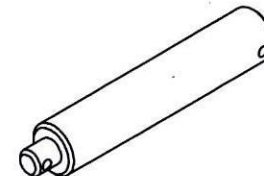
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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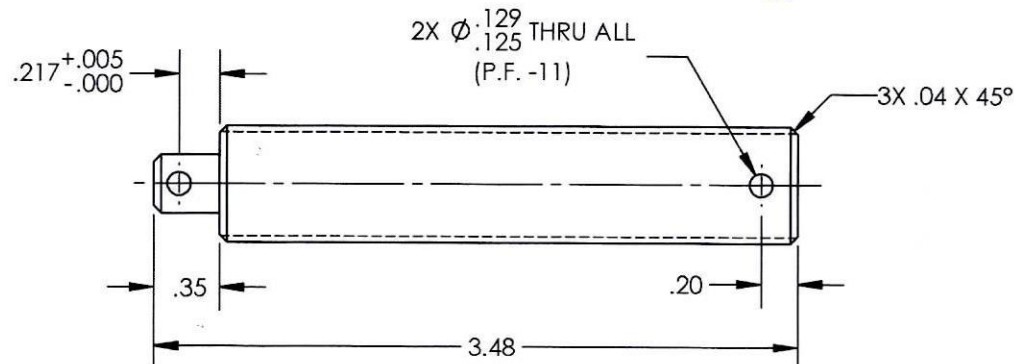
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-03 CH'D HOLE WAS Ø3.1 mm IS Ø.129 - .125, CH'D DIM WAS Ø.315 S.F. -07 IS Ø.3159 - .3150.	8/14/2015	RJC	JAG
6	16-0286	-03 CH'D DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -07), WAS .217 IS .217 +.005/.000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11), ADDED FINISH SPEC QMSI-6.2.2, B.O. REV'D.	2/28/2017	RJC	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170611 M.C.
1801-19



5/8-18 UNF -2A

Ø.3159
Ø.3155
(S.F. -07)



(-03)

ALL THREAD

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-03	REV 6
MAT'L B7 STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV'D	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 4 OF 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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BLANKET PURCHASE ORDER PO039090

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Conformity is required							
	172470		parts made from 1144 Steel Proof Round Bar	Firmed	3/1/18	10 pcs	AT 18/03/09 10 pcs	10 pcs	\$0.95/pcs	\$9.50
	171209		parts made from 1144 Steel Proof Round Bar	Firmed	3/1/18	18 pcs	AT 18/03/09 20 pcs	18 pcs	\$0.95/pcs	\$17.10
Sub Total:						28	0	28		\$26.60
4		RBE350A94-3700-C-03	Bolt -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required			0 pcs	0 pcs	0 pcs	\$1.79/pcs	
Line Item Note: Parts made from Grade B7 Medium Strength Steel										
	170611			Firmed	3/1/18	9 pcs	AT 18/03/09 9 pcs	9 pcs	\$1.79/pcs	\$16.11
Sub Total:						9	9	0		\$16.11
5		RBST2120-9	Pin Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required			0 pcs	0 pcs	0 pcs	\$0.89/pcs	
Line Item Note: parts are made from High Speed Tool Steel - Rockwell C60										
	171627			Firmed	3/1/18	4 pcs	AT 18/03/09 4 pcs	4 pcs	\$0.89/pcs	\$3.56
Sub Total:						4	0	4		\$3.56
6		RBST1007-9	Pin Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required			0 pcs	0 pcs	0 pcs	\$0.89/pcs	
Line Item Note: Parts made from High-Speed Tool Steel - Rockwell C60										
	171047			Firmed	3/1/18	4 pcs	AT 18/03/09 4 pcs	4 pcs	\$0.89/pcs	\$3.56
Sub Total:						4	0	4		\$3.56
7		RBE350A93-3303-02-5	Extractor Pin -Issue P/O to Groupe Altech; PO _____			0 pcs	0 pcs	0 pcs	\$1.05/pcs	



Certificat de Conformité / Certificate of Compliance

(007034-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Carrier, Acc. No.		Bon de commande Client Customer Purchase Order No.				
07-Mar-2018		Aman			PO039090				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0	
2	RBE350A94-3700-A-03 Rev.	RBE350A94-3700-A-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	24	24	0	0	0	
3	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0	
4	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	9	9	0	0	0	
5	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	4	4	0	0	0	
6	RBST1007-9 Rev.	RBST1007-9 BLACK OXIDE FINISH, MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0	
7	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 01 -BLACK OXIDE ON SST MIL-DTL-13924D BLACK OXIDE FINISH, MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0	
8	RBE350A93-3303-02-7 Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20	0	0	0	
10	RBT18560-5 Rev.	RBT18560-5 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0	
11	RBT18582 Rev.	RBT18582 ZINC PLATE, ASTM B633 TYPE 1 SC2	ZINC CH	6	6	0	0	0	
13	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0	



Certificat de Conformité / Certificate of Compliance

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Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.		
07-Mar-2018		Aman		P0039090		
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty Qté Scrap/ À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.